

Date: Thursday, 3/13/2008 10:19:23 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HI-STEP LEG ASSEMBLY		
Job Number	37925			Part Number	D2582		
Estimate Number	10355			Drawing Number	D2582 REV B		
P.O. Number				Project Number	N/A		
This Issue	3/13/2008	S.O. No.		Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	3/28/2008	Qty:	14
Previous Run	37452			Um:	Each		
Written By	<u>HF08 03 13</u>						
Checked & Approved By							
Comment	Est Rev:F Removed Manufacturing 05-11-07 JLM Est Rev:G Added part # to Sub 06-08-10 JLM Est Rev H New pick list 08.01.11 EC verified by: DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	37925A	STEP LEG	
		Comment: Sub-Component STEP LEG D2278 B <u>37925A</u> (21)	<u>B 37 452A</u> (7)
2.0	37925B	STEP SPACER	
		Comment: Sub-Component STEP SPACER D2322 B <u>B 36710B</u> (7) <u>B 37452B</u> (2) <u>B 37925B</u> (5)	
3.0	37925C	STEP SPACER	
		Comment: Sub-Component STEP SPACER D2279 B <u>B 2258E</u> (11) <u>B 31407D</u> (3)	
4.0	37925D	STEP SPACER	
		<u>B 37925D x11</u> ✓ <u>B 37452D x2</u> ✓ <u>B 36710 D x1</u> ✓ <u>ml</u> 08/04/02	
5.0	37925E	STEP SPACER	
		<u>B 37925E x9</u> ✓ <u>B 36710E x2</u> ✓ <u>B 37452E x3</u> ✓ <u>ml</u>	

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:23 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 37925

Part Number: D2582

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 22.0000 Each(s)/Unit Total: ~~220.0000~~ Each(s) 308

Pick:

Qty Part Number Description Batch
22 MS20470AD4-4 Rivet m106552 ?



7.0 MS20470AD45 Rivet, Universal Head



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~40.0000~~ Each(s) 56

Pick:

Qty Part Number Description Batch
4 MS20470AD4-5 Rivet m104156 ✓

ml

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2582 and

ml 08/04/08 x14

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/04/08 (x14)

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

- Identify and Stock
- Location: WT

AC 08/04/08 x14

11.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-08

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

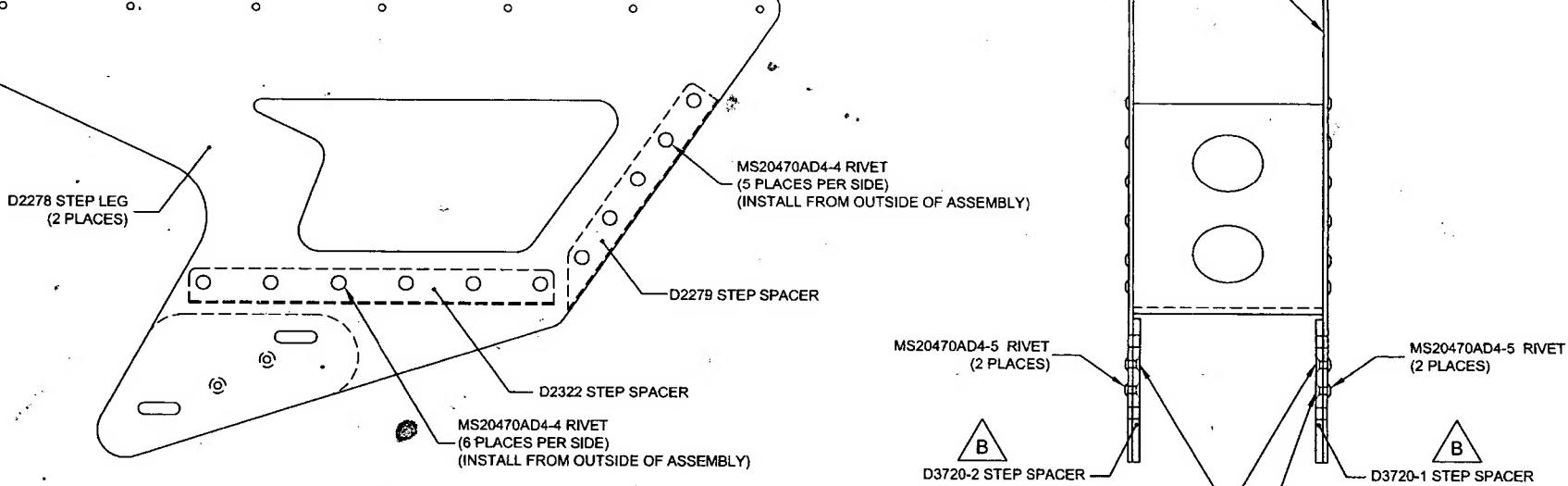
C

B

B

A

A



D2582 STEP LEG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AUTOMATIC
WORK STOPPAGE
NO. 37925

D2582 STEP LEG ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D2582	STEP LEG ASSEMBLY
2	D2278	STEP LEG
1	D2279	STEP SPACER
1	D2322	STEP SPACER
1	D3720-1	STEP SPACER
1	D3720-2	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

NOTES:

- 1) FINISH: NONE
- 2) IDENTIFICATION: IDENTIFY WITH DART P/N "D2582" USING FINE POINT PERMANENT INK MARKER WHERE INDICATED
- 3) WEIGHT: 1.25 lbs.

B	REPLACE D2280 SPACERS WITH D3720-1/2 SPACERS REFERENCE NCR 263 UPDATE DRAWING FORMAT	PH	07.12.27
A	NEW ISSUE	CP	01.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	ME	D2582	SHEET 1 OF 1
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	STEP LEG ASSEMBLY	NTS
DATE	07.12.27	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08.01.10 AM